

Date: Monday, 8/21/2006 2:11:09 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPAD	
Job Number	: 28249		Part Number	: D26483	
Estimate Number	: 10313		Drawing Number	: D2648 REV D	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 8/21/2006	S.O. No. : N/A	Drawing Revision	: D	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 9/5/2006	
Previous Run	: 28123		Qty:	200 Um: Each	
Written By					
Checked & Approved By					
Comment	: Est: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF Est Rev:F Now on Waterjet 06-08-14 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S16GA	1010/1025/A21/6aA SHEET  
Comment: Qty.: 0.0788 sf(s)/Unit Total : 15.7500 sf(s) 1010/1025/A21/6aA SHEET (M1010S16GA) Batch: <del>M1010S16GA</del> M1010S16GA 		
2.0	WATER JET	FLOW WATER JET  
Comment: FLOW WATER JET 1-Cut as per Dwg D2648 *****CUT WITH FILE D2648-1***** Dwg Rev: <u>D</u> Prog Rev: <u>D</u>  2-Deburr if necessary  <u>SAD</u> 06:08:28 <u>Not Deburred</u> 		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  
Comment: INSPECT PARTS AS THEY COME OFF MACHINE  <u>SAD</u> 06:08:28		
4.0	QC8	SECOND CHECK  
Comment: SECOND CHECK  <u>Counted</u> 		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary  <u>SAD</u> 06:09:14 		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

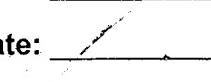
NCR: Yes

 NoDQA: 

Date: 06/21/19

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: 

Date: Monday, 8/21/2006 2:11:10 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 28249

Part Number: D26483

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.

SA 0 06/09/20 202

2-Identify as D2648-3

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch  
A/R560Hardcoat m100294 , m102756

1-Weld as per Dwg D2648 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

MF.

06-11-28

202

8.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

06/11/28 202

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/11/28 202

10.0 POWDER COATING

POWDER COATING



M 101601



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-hy/06/12/15 (202)

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC

06/12/19

202

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: F017

FC 06 12 19 202

13.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/12/19 202

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries.

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

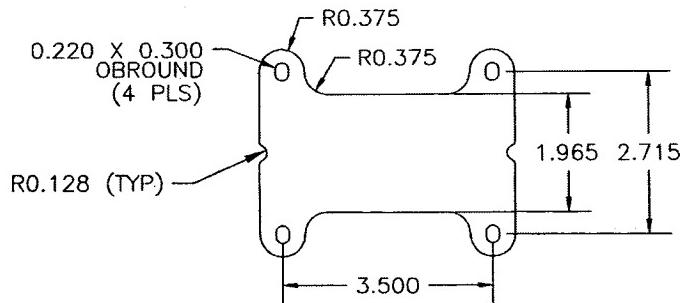
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

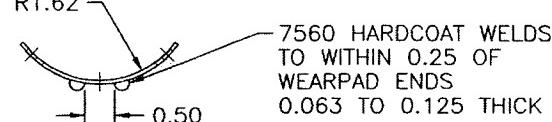
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

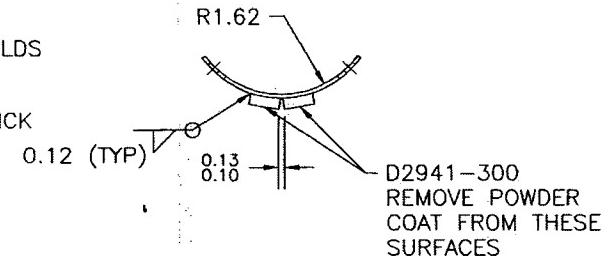
D2648-1 FLAT PATTERN



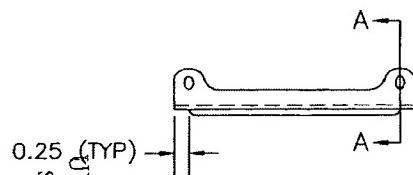
SECTION A-A



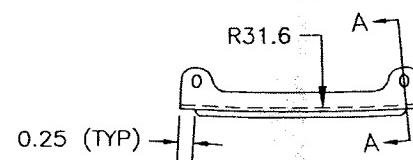
SECTION B-B



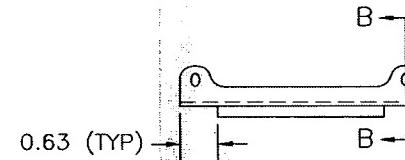
D2648-3 LONGITUDINAL BEND  
(MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND  
(MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND  
(MADE FROM D2648-1)



NO. 2849  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
BREKES ALL SHARP CORNERS 0.063 MAX  
ENGINEERING COPY  
RETURN TO  
DRAFTING  
UNCONTROLLED  
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)  
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

RELEASED  
04.12.20 DS

COPY  
04.12.20 DS

D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBROUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. REV. D D2648 SHEET 1 OF 1
DATE		TITLE SCALE 99.11.17 WEARPAD 1:2

DART AEROSPACE LTD	Work Order:	28249
Description:	Part Number:	D26483
Inspection Dwg:	Rev:	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article X Prototype

Measured by:	SAN
Date:	06/08/28

Audited by:	
Date:	06-08-29

<b>Prototype Approval:</b>	
<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	